

Thursday, January 27, 2011 1:13:27 PM



Accept

**Setup . Start**

Stop



Start Date: 1/28/2011 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 2/14/2011 **Req'd Qty:** 1.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** mf

Date: 11-01-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65942

Thursday, January 27, 2011 1:13:27 PM

Page 2

Item ID: D4032-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PAP 65941

0.00

Packaging

11/24/15 C

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*CK 11/02/16**mf
11-02-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)



Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC
10.03.23 verified by:EC
verified by:EC
IPP Rev:B as per RevA DD 10.04.20 verified by:EC
IPP Rev:C as per RevA DD 10.04.20 verified by:EC
IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC
IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No			100	Each	11.0000	1	1			
<div> <div>Location</div> <div>ST506</div> <div>64443</div> <div>65094</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>3</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2535 Spring		Manufactured	No			100	Each	54.0000	2	2			
<div> <div>Location</div> <div>ST504</div> <div>58331</div> <div>64280</div> </div> <div> <div>Loc Qty</div> <div>54</div> <div>14</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div>58331</div> <div></div> </div>													
D2537 Bushing		Manufactured	No			100	Each	26.0000	2	2			
<div> <div>Location</div> <div>ST504</div> <div>64064</div> </div> <div> <div>Loc Qty</div> <div>26</div> <div>26</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

8

65094

58331

64064

64064

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Manufactured No

100

Each

18.0000

6

6



Washer



65674 14 E

Location

Loc Qty

Loc Code

ST095

17

64589

17

ST096

1

57144

1

64589 54

D3953-3 Manufactured No

100

Each

7.0000

2

2



Gas Spring Stud, Lid



65620 14 E

Location

Loc Qty

Loc Code

ST096

7

65052

7

65052 14

D3953-7 Manufactured No

100

Each

10.0000

2

2



Spring Spacer



65053 14 E 11/2/7

Location

Loc Qty

Loc Code

ST096

9

65053

9

ST103

1

65336

1

65053

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100

Each

22.0000

2

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST096

17

65136

17

ST100

3

64450

3

ST103

2

60008

2

65136

D3953-17 Manufactured No

100

Each

33.0000

2

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST097

31

65138

31

ST101

2

57143

1

64021

1

65138

D3953-19 Manufactured No

100

Each

20.0000

1

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST

2

59213

2

ST097

18

64810

18

64810

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Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, January 27, 2011 1:13:22 PM

Page 4

Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-21
Gas Spring Bracket

Manufactured No

100

Each

9.0000

1

1

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

4

57145

2

59214

2

D3969-3
Spring (Basket Lid)

Manufactured No

100

Each

18.0000

1

1

Location

Loc Qty

Loc Code

ST272

18

64285

18

D4017-041
Short Basket Base Assembly (350)

Manufactured No

100

Each

0.0000

1

1

D4018-041
Short Basket Lid Assembly (350)

Manufactured No

100

Each

0.0000

1

1

AN3-14A
Bolt

Purchased No

100

Each

64.0000

4

4

Location

Loc Qty

Loc Code

ST351

64

114941

14

115108

50

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Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A
Bolt

Purchased No

100 Each

102.0000

2

2

Location

Loc Qty

Loc Code

ST352

102

114752

52

116419

50

AN4-12
Bolt

Purchased No

100 Each

26.0000

3

3

Location

Loc Qty

Loc Code

ST357

26

114784

2

116419

24

AN5-17A
Bolt

Purchased No

100 Each

140.0000

4

4

Location

Loc Qty

Loc Code

ST339

140

116003

40

116590

100

AN310-4
NUT

Purchased No

100 Each

18.0000

3

3

Location

Loc Qty

Loc Code

ST324

18

116075

18

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 6

Work Order ID: 65942

Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011



Required Date: 2/14/2011

Start Qty: 1.00



Required Qty: 1.00

AN310C4	Purchased	No	100	Each	10.0000	2	2	
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST349	10	
114306	10	

MS21042L3	Purchased	No	100	Each	3,053.000	6	6	
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3053	
114784	9	
115835	544	
116391	900	
116540	800	
116549	800	

MS21042L5	Purchased	No	100	Each	1,235.000	4	4	
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	26	
114813	26	
ST300	1209	
115156	5	
115594	500	
116104	8	
116105	496	
116548	200	

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Page 6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, January 27, 2011 1:13:23 PM

Page 7

Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-151 Purchased No

100 Each

566.0000 3 3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

566

17566

566

MS24665-300 Purchased No

100 Each

28.0000 2 2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

28

110123

28

NAS1149F0432P Purchased No

100 Each

94.0000 6 6



Washer

Location

Loc Qty

Loc Code

ST275

94

112940

92

114405

1

116169

1

NAS1149C0432R Purchased No

100 Each

154.0000 2 2



Washer

Location

Loc Qty

Loc Code

ST297

154

114292

36

114742

27

116304

91

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 1:13:23 PM

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Work Order ID: 65942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P Purchased No

100 Each

278.0000 8 8



WASHER

Location

Loc Qty

Loc Code

ST275

278

18057

278

NAS1149F0563P Purchased No

100 Each

150.0000 4 4



Washer

Location

Loc Qty

Loc Code

ST298

150

114576

150

18057

4

114576

Thursday, January 27, 2011 1:13:23 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

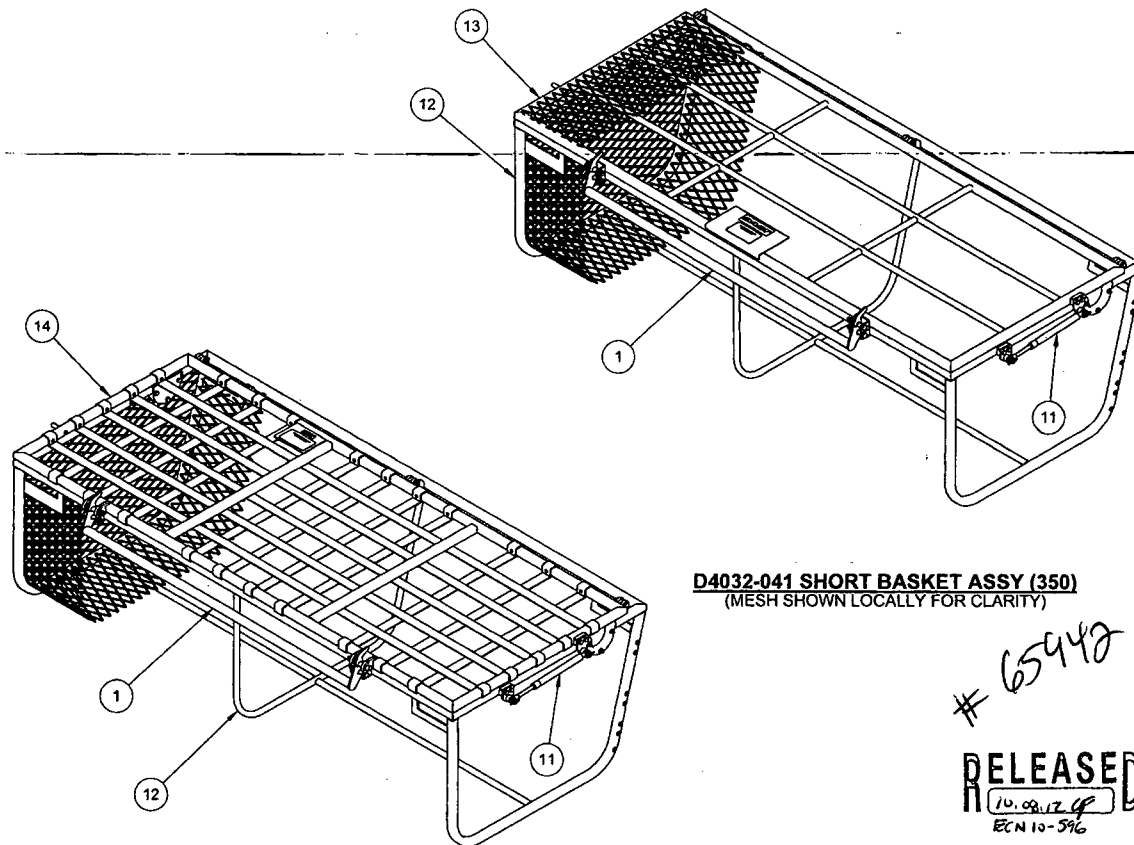
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	195		
DRAWN	9		
CHECKED			
MFG. APPR.	JES		
APPROVED	NP		
DE APPR.	CH		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4032** REV. D
SHEET 1 OF 3

TITLE **SHORT BASKET ASSY (350)** SCALE
— NTS

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65940
RELEASED
10.09.12
ECN 10-596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

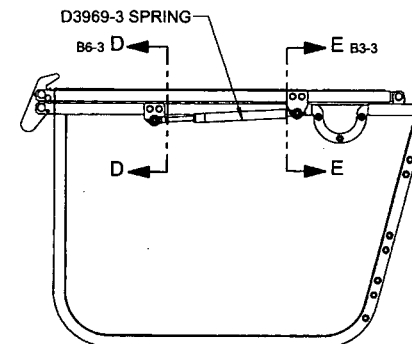
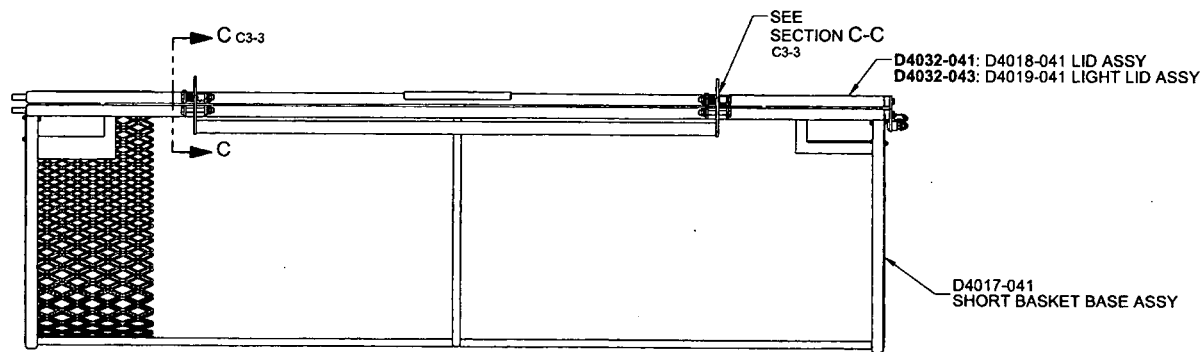
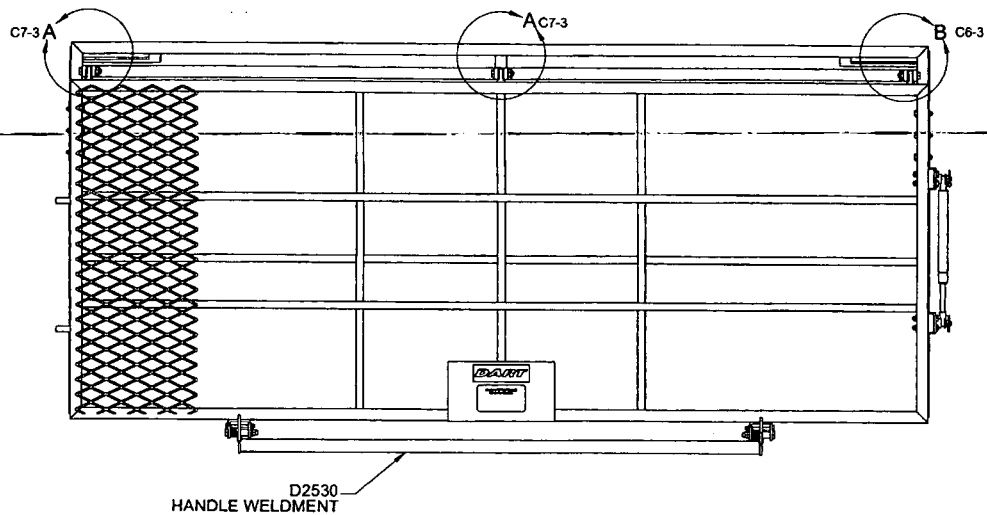
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#65942

D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)
D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350) - NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

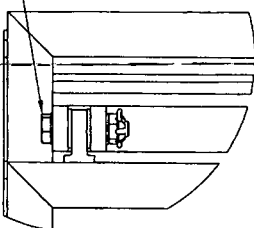
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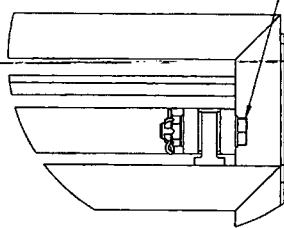
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



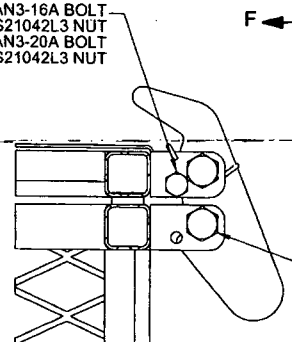
DETAIL A D8-2
D8-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT

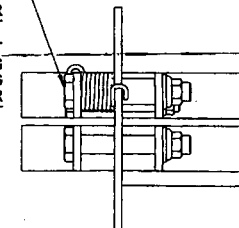


SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530 WELDMENT
REF

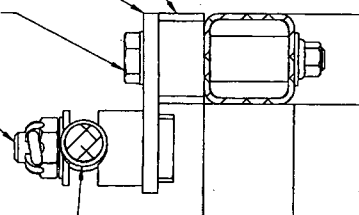
D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2



D3953-17 GAS SPRING SPACER

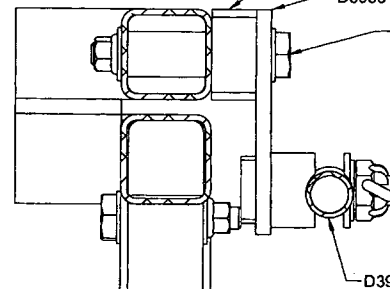
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2



RELEASED
10.08.17.02

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 3 OF 3
APPROVED	JM	TITLE	SCALE
DE APPR.	JM	SHORT BASKET ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries